

**Work Order ID 80021**

Thursday, February 09, 2012 8:11:12 AM

**\*80021\***

Page 1

Item ID: D4004-3

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Strut Lock Bracket

Start Date: 2/10/2012 Start Qty: 8.00

**\*8\***

Cust Item ID:

Required Date: 2/17/2012 Req'd Qty: 8.00

**\*8\***

Customer:

Reference:

Approvals: Process Plan: *MF*Date: *12-02-09*

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D4004

A

100

0.00

**\*100\***

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg (D4004-3F)

Dwg Rev: *A*Prog Rev: *A**7024 .062*

2-Deburr if necessary

*B12-2-10**(18)*

110

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*110\***

QC

Memo

0.00

Quality Control

*B12-2-10*

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursTool ID Tool # Plan  
Code Accept Reject Reject Insp.  
Qty Qty Number Stamp

120

QC8- Inspect parts - second check

0.00

**\*120\***

QC

Memo

0.00

Quality Control

130

Bend as per dwg

0.00

**\*130\***

Brake NC

Memo

0.00

Brake NC

140

QC5- Inspect part completeness to step on W/O

0.00

**\*140\***

QC

Memo

0.00

Quality Control

S1267/10

CLB

SB 12/02/13

17

S1267/13

47

PTD  
next page

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4604-3 PAR #: \_\_\_\_\_ Fault Category: Small FA3 NCR: Yes No DQA: [Signature] Date: 12/2/17  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: [Signature] Date: 12/2/17

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/02/13	130	1 part was scrap out of tolerance at the setup was 2.110 suppose to be 2.050 P.C Process/operation error	S 12/02/13 057042	Scrap + destroy no replace	S 12/02/13	S 12/02/13	S 057042 12/02/13	S 12/02/13

NOTE: Date & initial all entries

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**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Strut Lock Bracket

Start Date: 2/10/2012 Start Qty: 8.00

**\*8\***

Cust Item ID:

Required Date: 2/17/2012 Req'd Qty: 8.00

**\*8\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00

**\*150\***

HandFinish

Memo

0.00

Hand Finishing

17 BR 12.2.13

160

QC3- Inspect Part Finish

0.00

**\*160\***

QC

Memo

0.00

Quality Control

17 X M-12/02/13

170

Identify as per dwg &amp; Stock Location GA

0.00

**\*170\***

Packaging

Memo

0.00

Packaging

SB 12/02/13

(17)

**Work Order ID 80021****\*80021\***

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Start Date: 2/10/2012 Start Qty: 8.00 **\*8\***

Cust Item ID:

Required Date: 2/17/2012 Req'd Qty: 8.00 **\*8\***

Customer:

Reference:

Approvals: Process Plan: Date:

Run Start **\*NR1\***

QC: Date:

Tooling: Date:

Stop **\*NR2\***

SPC (Y/N): Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursTool ID Tool # Plan  
Code Accept Reject Reject Insp.  
Qty Qty Number Stamp

180

QC21- Final Inspection - Work Order Release

0.00


**\*180\***

QC

Memo

0.00

Quality Control

 M.L.J. 12/02/14M.L.J. 12/02/14  
(17)

# Picklist Print

Thursday, February 09, 2012 8:11:11 AM

Page 1

Work Order ID: 80021

Parent Item: D4004-3

Parent Item Name: Strut Lock Bracket

Start Date: 2/10/2012

Required Date: 2/17/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP rev A 09.12.15 new issue Prelim EC verified by:DD IPP Rev:B 10.05.17 as per ECN10-562 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063 2024-T3 .063 sheet		Purchased	No			100	sf	211.5000	0.024	0.2021053		12-2-10 <sup>15</sup>	

Location

Loc Qty

Loc Code

MAT022

211.5

117392

19.5

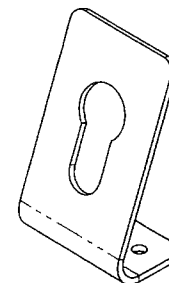
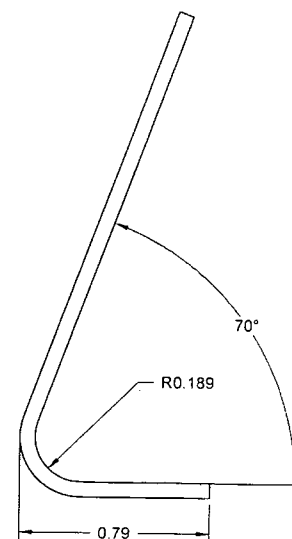
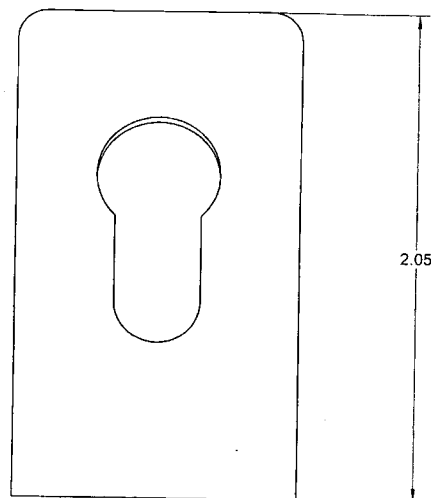
119916

192

117392

18

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4004-3	REF JCA-M47-2-19



**D4004-3 STRUT LOCK BRACKET**

**RELEASED**  
2010-05-05  
MB

- NOTES:**
- 1) MATERIAL: MADE FROM D4004-3F
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.02 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4004	SHEET 5 OF 11
APPROVED		TITLE	SCALE
DE APPR.		<b>SIDE RESTRAINT</b>	NTS
DATE	10.02.10	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

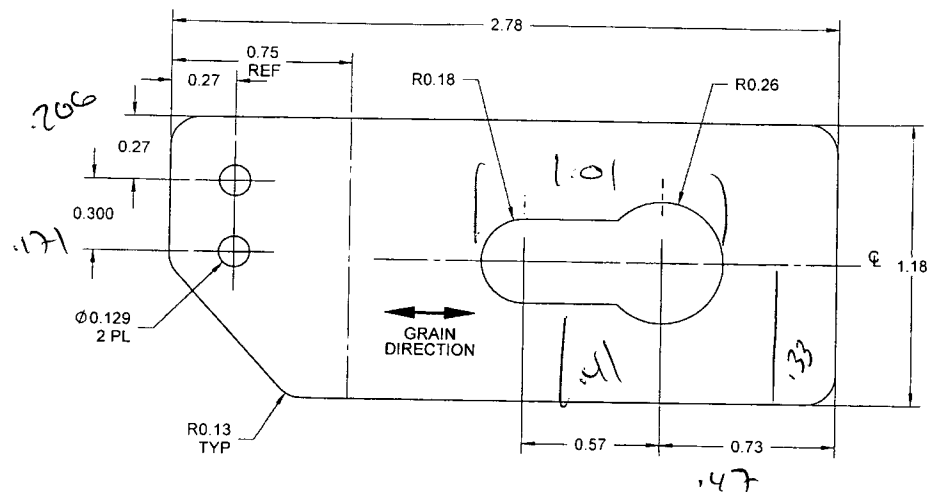
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





**D4004-3F FLAT PATTERN**

**RELEASED**  
2010-05-05  
MD

**NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK  
PER QQ-A-250/4 OR AMS-QQ-A-250/4  
OR AMS 4037 OR ASTM B209  
REF DART SPEC M2024T3S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
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DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		<b>D4004</b>	SHEET 6 OF 11
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